

Work Order ID 55074

January 5, 2010 3:06:10 PM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 05/01/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *PP*Date: *10-1-05*

Tooling:

Date:

Run Start



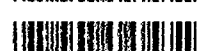
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

8/2/16

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

PC/2/12 (6)

170

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8/2/16**(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55074

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Page 2

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 05/01/2010 Start Qty: 8.00



Cast Item ID:

Required Date: 15/01/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-
011 Location: 11A

Ren A

10-2-16

SL



190



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/02/10 JF

MF

10-2-16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 3:06:14 PM

Page 1
4

Work Order ID: 55074

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Comments:

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416 28 Washer		Purchased	No				Each	1,489.000	147 192.0000			

S 46

MA01149 20430
113706

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1489	
103691	20	
104215	6	
108161	329	
110523	340	
111279	101	
111916	482	
112314	211	
16941	0	

SP

AN4-17A 127

Bolt

Purchased

No

160

Each

1,313.000

72
96.0000

✓

10/12/10

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1313	
105653	5	
107321	10	
109061	5	
111758	293	
112314	1000	

M711758

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

January 5, 2010 3:06:14 PM

Work Order ID: 55074

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2182B Rubber Cushion	160 5.0"	Manufactured	No			160	f	323.0160	20.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

29.886

28042

7.33

30872

0.33

45405

22.226

Main Warehouse

ST410

293.13

52649

293.13

D2274

Manufactured

No

160

Each

41.0000

96.0000

Radius Block

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

41

52644

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 3:06:15 PM

Work Order ID: 55074



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00 6

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Loc Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2432 24 		Manufactured	No			160	Each	3.0000	16.0000	72		
206 (24") Bearpaw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	3	
30576	1	
53432	2	

D2438 64 		Manufactured	No			160	Each	84.0000	48.0000	36		
Clamp												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	84	
46113	5	
53221	79	

D2529 124 		Manufactured	No			160	Each	746.0000	96.0000	22		
Washer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	746	
52745	746	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 5, 2010 3:06:15 PM

Work Order ID: 55074



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 8.00 6

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 Nut		Purchased	No			160	Each	4,157.000	96.0000			

6.56

14/2/12 (2)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4157

102552

6

104248

6

110507

184

111827

2961

113422

1000

15924

0

111/1827

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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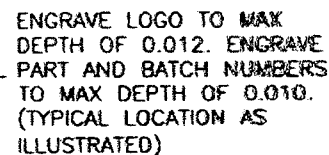
NOTE: Date & initial all entries




93.06.17 KB



55074
P/10-1-05

EFFECTIVE	DEQS
9143	



~~0.260 (TYP)~~ 
~~0.75 C.BORE~~ 0.93 C.BORE
~~0.35 DEEP FROM TOP (MIN.)~~
 0.30 DEEP FROM BOTTOM
~~(LEAVE 0.300 MIN.)~~ 
 (LEAVE 0.650 MIN.)
~~0.375~~ 

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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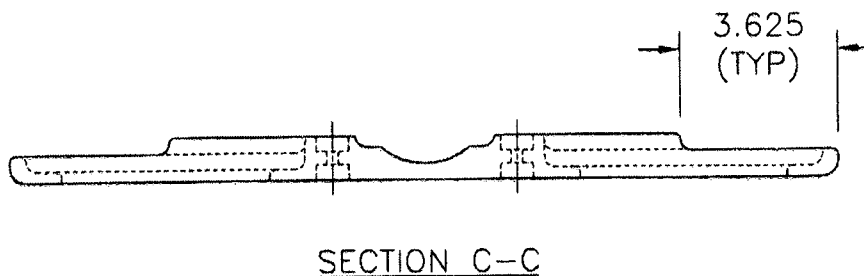
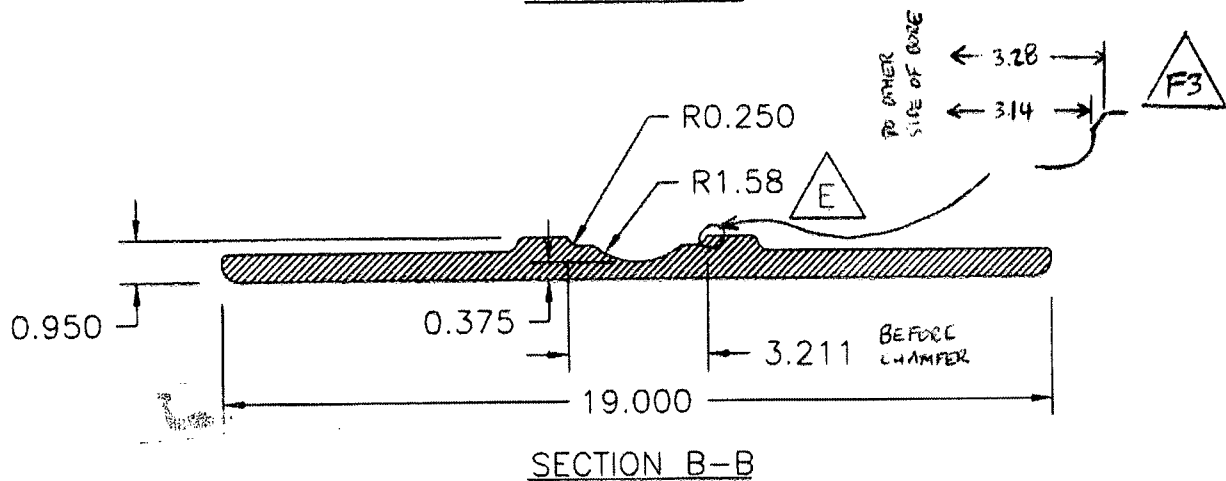
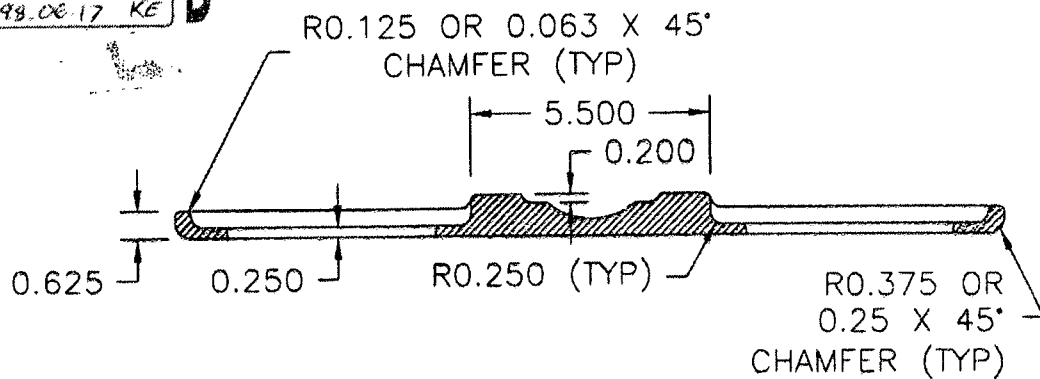
NOTE: Date & initial all entries



w/055074

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.08.17 KE



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

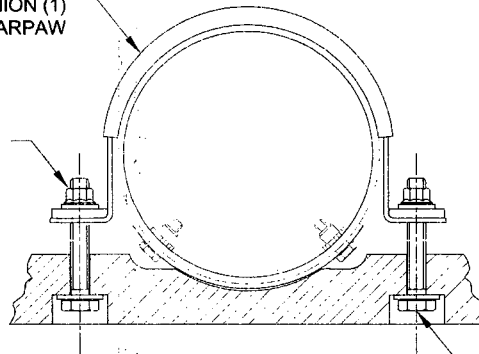
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D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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